

Date: Tuesday, 29/07/2008 1:45:31 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER TUBE
Job Number	: 40776		
Estimate Number	: 13498		
P.O. Number	:	Part Number	: PB6743001205
This Issue	: 29/07/2008 S.O. No. :	Drawing Number	: B6743001 P.16
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 05/08/2008
Checked & Approved By	: <u>mf 08-07-29</u>	Qty:	8 Um: Each
Comment	: Est Rev:A 08-07-24 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1750W065	6061T6 RDTUBE 1.750 X 0.65W
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Comment: Qty.: 3.7958 f(s)/Unit Total: 18.9788 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: m108551=3 m108659=2

08-07-29

2.0	BAND SAW	BAND SAW
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2-cut a 27 degree angle on one end of tube as per dwg

2- deburr

Scrp

08-07-29

PH

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- drill holes and mill slot as per dwg PB67-43001

2- deburr

see last page
08-07-29

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08-07-29

5.0	PB6743001199	Outer Tube End Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Outer Tube End Cap





batch: B44039

3X

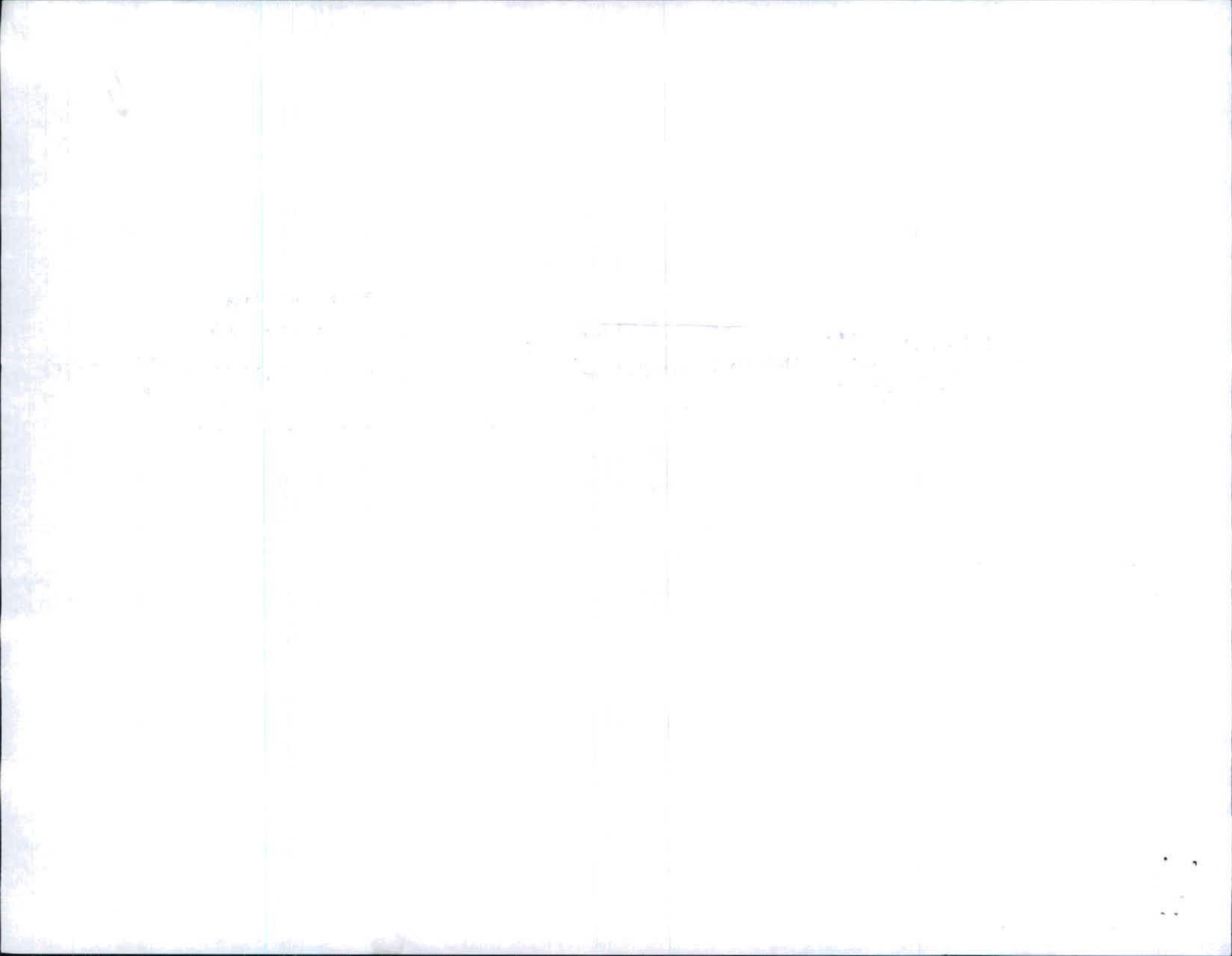
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-205 PAR #: N/A Fault Category: Prod / As Leg. NCR: Yes No DQA: 12 Date: 08/08/27
 QA: N/C Closed: 12 Date: 08/08/28

NCR: 40776		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/07/29	# 20	operator the Button cut angle on the wrong operation to the the holes R.C. operator error Human error		Scrap and Destroy the Replace. Qty 3 NO	SAD 08/08/25	 08/10/27		 08/11/29

NOTE: Date & initial all entries



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Drawing Name: OUTER TUBE

Job Number: 40776

Part Number: PB6743001205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld end cap as per dwg PB67-43001

2-grind end cap flush

SP 08-07-30
SP 08-07-30

(3x)

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.08.26

MS21039-1-04

REFERENCE ONLY

2

2

2

2